

ship June 22

Work Order ID 146734

146734

Page 1

Friday, May 20, 2016 4:14:09 PM

Item ID: D350-607-545 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH
 Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/1/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 16-05-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	D								
DSI9699	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-545 CHG007								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging	***Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ***								

9-89 D-16

JUN 21 2016

JUN 21 2016

MLJ 16-06-21

DAS
6
9-89
DAS
28
9-89

JUN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 146734***146734***

Page 2

Item ID: D350-607-545

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							
115									
QC	Memo	0.02							
Quality Control	***Inspect labe lon lid***								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									
130	Pick Kit	0.00							
130									
Packaging	Memo	0.01							
Packaging	Package as per PPPD350-607-545								

SMP
10/6/22SMP
JUN 21 2016SMP
10/6/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Work Order ID 146734

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146734

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Item ID: D350-607-545

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

MW JUN 22 2016

SH 6/22/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 146734

146734

Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B
10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:C 11.02.09
add to install label DD verf by:EC IPP REV:D 12.03.06 AS PER
ECN12-535 DD VERF:EC IPP REV:E 12.07.24 AS PER ECN 12-610
DD VERF:EC IPP REV:F 13.08.21 CHG005 / ECN 13-624 DD
VERF:JLM IPP REV:G 14.06.09 AS PER ECN14-572 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-220		Manufactured	No				Each	8.0000		1			DAS 28 9-89
D4086-220									**				DAS 6 9-89
Placard													
	DAS 27 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST078				8					
				135395				8					
D4917-320		Manufactured	No				Each	15.0000		1			DAS 6 DAS 9-89 28 9-89
D4917-320									**				
Placard, Max Load													
	DAS 27 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST137				15					
				127309				4					
				138529				11					
D350-607-511		Manufactured	No			110	Each	2.0000		1			DAS 6 DAS 9-89 28 9-89
D350-607-511									**				
Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH													
	DAS 27 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG128				2					
				142813				2					

JUN 21 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 146734

146734

Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

D2690-6	Manufactured	No	110	Each	36.0000	Start Qty: 1.00	Required Qty: 1.00	DAS 6 27 9-89
D2690-6						**	146658	DAS 6 27 9-89
Lanyard								9-89

DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST009	36	
144944	1	
145224	10	
146036	25	

D3912-041	Manufactured	No	110	Each	4.0000	1	1	DAS 6 27 9-89
D3912-041						**	145537	DAS 6 27 9-89
Eyebolt Receiver Assy								9-89

DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST057	4	
144827	4	

D4032-041	Manufactured	No	110	Each	0.0000	1	1	DAS 6 27 9-89
D4032-041						**	146979	DAS 6 27 9-89
Short Basket Assembly (350)								9-89

D4151-041	Manufactured	No	110	Each	13.0000	1	1	DAS 6 27 9-89
D4151-041						**		DAS 6 27 9-89
Basket Fwd Hardpoint Assembly, Lower								9-89

DAS
27
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST087	5	
143335	4	
143338	1	
ST090A	8	
143336	4	
145589	4	

JUN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

D4151-043

Manufactured No

110

Each

15.0000

Start Qty: 1.00

Required Qty: 1.00

D4151-043

Basket Fwd Hardpoint Assembly, Upper

DAS
27
9-89

Location

Loc Qty

Loc Code

ST088

6

143358

4

143360

2

ST090A

9

143359

4

146060

5

**

DAS
28
6 9-89
9-89

D4150-041

Manufactured No

110

Each

13.0000

1

1

D4150-041

Attachment Arm Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST087

3

143343

3

ST090A

10

143344

4

143345

3

145783

3

**

DAS
6
9-89
DAS
28
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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Misidentified ☐	Past Due ☐								

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Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™,Short,HD Lid,Spacepod™ & Squirrel Cheek Comp.,
LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

AN4-13A Purchased No 110 Each 313.0000 Start Qty: 1.00 6 6 Required Qty: 1.00
Bolt **DAS 27 9-89** ****** **DAS 6 9-89 28 9-89**

Location Loc Qty Loc Code

FG 20

122808 20

GA 60

m134167 36

m134634 24

O003 200

m134754 200

ST344 33

m134634 33

AN4C15 Purchased No 110 Each 42.0000 1 1 **DAS 6 9-89 28 9-89**
Bolt **DAS 27 9-89** ******

Location Loc Qty Loc Code

over003 32

M1134567 20

M134257 12

ST343 10

M133694 10

AN310C4 Purchased No 110 Each 108.0000 1 1 **DAS 6 9-89 28 9-89**
Nut **DAS 27 9-89** ******

Location Loc Qty Loc Code

OVER007 30

M134370 30

ST331 78

M133990 28

M134762 50

JUN 21 2016

Friday, May 20, 2016 4:14:14 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Friday, May 20, 2016 4:14:14 PM

Work Order ID: 146734

146734

Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

MS17984-C413

Purchased

No

110

Each

53.0000

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Quick Release Pin

**

134528

DAS

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

over005

50

145506

10

m134052

10

m134528

10

m13462710

10

m134664

10

ST315

3

m133686

3

DAS
27
9-89

MS21042L4

Purchased

No

110

Each

2,035.000

6

6

MS21042L4

Locknut

**

DAS

DAS 28
6 9-89
9-89

Location

Loc Qty

Loc Code

GA

187

m133769

187

OVER007

1500

m134676

500

m134762

1000

ST303

251

m134606

251

ST305

97

m130922

97

DAS
27
9-89

JUN 21 1989

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		OTHER : ☐									

Picklist Print

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Work Order ID: 146734

146734

Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

MS24665-151	Purchased	No	110	Each	138.0000	1	1	Start Qty: 1.00	Required Qty: 1.00
MS24665-151									
Cotter Pin									
									DAS 28 6 9-89 9-89

DAS 27 9-89

NAS1515H4L	Purchased	No	110	Each	317.0000	2	2		
*NAS1515H4L *									
Washer									DAS 28 6 9-89 9-89

DAS 27 9-89

NAS1149F0432P	Purchased	No	110	Each	1,150.000	12	12		
NAS1149F0432P									
WASHER									DAS 28 6 9-89 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
GA	64	
m128401	64	
ST289	74	
m134294	74	
FG	23	
103691	3	
m132189	20	
ST260	294	
m133483	194	
m134376	100	
ST260a	1000	
M134502	1000	
ST262	29	
M133990	29	
st268	121	
M132677	121	

12

JUN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Page 7

Friday, May 20, 2016 4:14:15 PM

Work Order ID: 146734

146734

Parent Item: D350-607-545

D350-607-545

Parent Item Name: QR Heli-Utility-Basket™, Short, HD Lid, Spacepod™ & Squirrel Cheek Comp., LH/RH

Start Date: 5/24/2016

Required Date: 6/1/2016

NAS1149C0463R

Purchased

No

110

Each

324.0000

Start Qty: 1.00

Required Qty: 1.00

3 3

NAS1149C0463R

Washer

DAS

DAS 28
6 9-89

JUN 21 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

70

m127306

70

ST260a

200

m134167

200

ST266

54

m133077

54

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
				OTHER : ☐					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6

REF TCCA STC: SH94-14

REF FAA STC: SR00213NY

REF EASA STC: EASA.10016996

REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.

3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole. Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).

3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

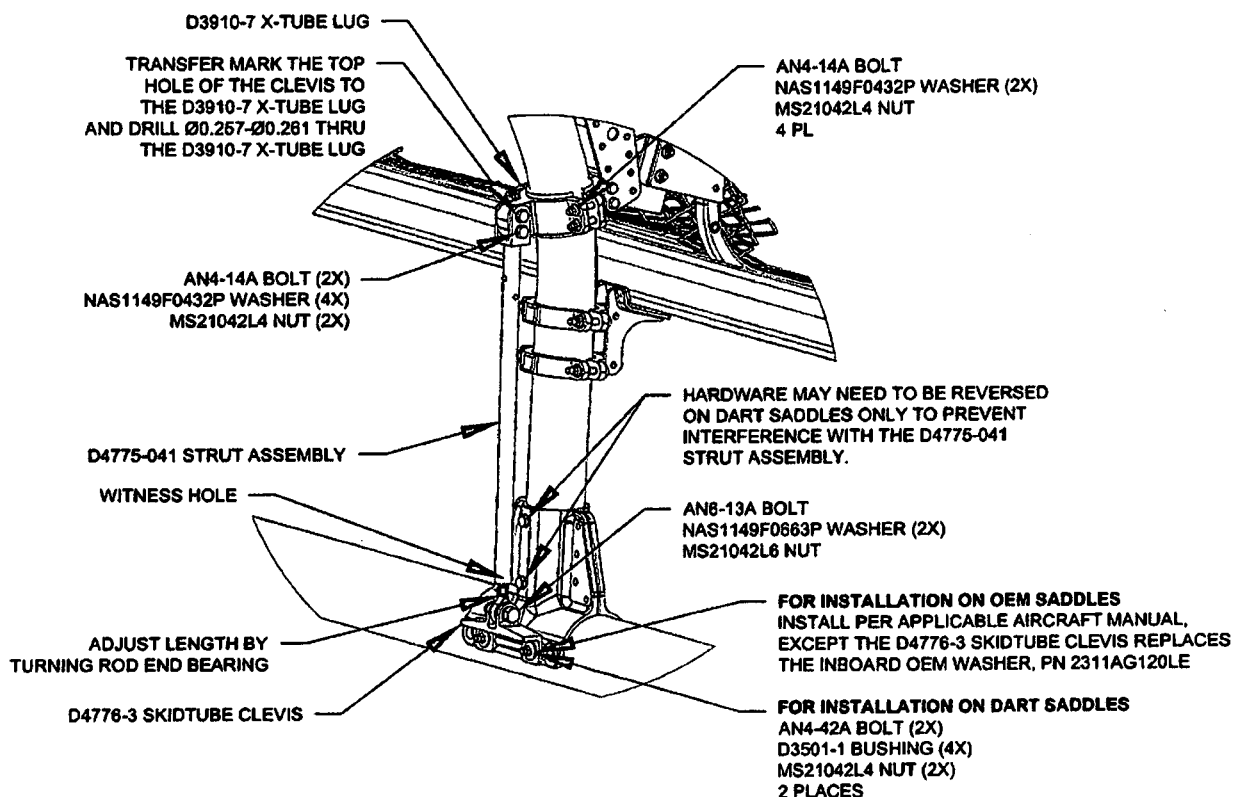


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	14.05.16
CERT. NO.:	SH94-14
ISSUE NO.:	6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
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5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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Revision: D

Date: 14.01.02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

6.0 CONVERSION & OPTIONAL KITS PARTS LIST

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT
1	1	1	1		D2530	HANDLE ASSEMBLY
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D3501-1	BUSHING
				2	D3910-5	X-TUBE LUG
1					D3914-041	LONG BASKET LID ASSEMBLY
		1			D3915-041	LONG BASKET LID ASSEMBLY (LIGHTWEIGHT)
6	6	6	6		D3917-3	WASHER
1	1	1	1		D3953-9	GAS SPRING WASHER
				4	D3984-030	RUBBER EXTRUSION, X-TUBE
	1				D4018-041	SHORT BASKET LID ASSEMBLY
			1		D4019-041	SHORT BASKET LID ASSEMBLY (LIGHTWEIGHT)
1					D4086-200	PLACARD, MAX LOAD
1					D4086-210	PLACARD, MAX LOAD
		1			D4086-215	PLACARD, MAX LOAD
	1	1			D4086-220	PLACARD, MAX LOAD
	1		1		D4086-232	PLACARD, MAX LOAD
			1		D4086-243	PLACARD, MAX LOAD
				2	D4775-041	STRUT ASSEMBLY
				2	D4776-3	SKIDTUBE CLEVIS
1				1	D4917-300	PLACARD, MAX LOAD
1				1	D4917-310	PLACARD, MAX LOAD
		1		1	D4917-315	PLACARD, MAX LOAD
	1	1		1	D4917-320	PLACARD, MAX LOAD
	1		1	1	D4917-332	PLACARD, MAX LOAD
2	2				AN3-16A	BOLT
		2	2		AN3-20A	BOLT
3	3	3	3		AN4-12	BOLT (DRILLED)
				12	AN4-14A	BOLT
					AN4-22A	BOLT
				4	AN4-42A	BOLT
2	2				AN5-17A	BOLT
		2	2		AN5-21A	BOLT
				2	AN6-13A	BOLT
3	3	3	3		AN310-4	CASTELLATED NUT
2	2	2	2		AN310C4	CASTELLATED NUT
					AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
2	2	2	2		MS21042L5	NUT (OR MS21042-5)
				16	MS21042L4	NUT (OR MS21042-4)
				2	MS21042L6	NUT (OR MS21042-6)
3	3	3	3		MS24665-151	COTTER PIN
2	2	2	2		MS24665-300	COTTER PIN
2	2	2	2		NAS1149C0432R	WASHER
6	6	6	6	24	NAS1149F0432P	WASHER
2	2	2	2		NAS1149F0563P	WASHER
				4	NAS1149F0663P	WASHER

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Revision: D

Date: 14.01.02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

REFERENCE ONLY

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6**
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
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5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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